








Work Order ID 51334



August 19, 2009 11:21:07 AM



Page 1

Item ID: D3838-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket Lid, LH)
Start Date: 08/19/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 08/25/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: mf Date: 09-08-19 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3838-1 and D3838-3 rib as per dwg D3838□2- c'sink hole as per dwg□3- remove identification markings□4- deburr								
110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

SAD 09-08-20 (2)

27 8/21/09/21

(240)

(2)

q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51334

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Page 2

Item ID: D3838-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 08/19/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 08/25/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 ☐ A/R ER316 S.S. Rod
Batch: M108160 ☐ 2- grind weld flush where indicated on dwg D3838 ☐
3- weld D3759-1 bushing as per dwg D3838 ☐ 4

09-08-24 ②

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

09-08-24

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 8/26/09

6

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Picklist Print

August 19, 2009 11:21:07 AM

Page 1/1

Work Order ID: 51334



Parent Item: D3838-041RevA



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 08/19/2009

Required Date: 08/25/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	58.0000	2.0000			

Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 58

50000 22

51136 36

M304TS0.750W.065

Purchased

No

120

f

1,352.362 2.1720



304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 6.307103691

112051 -0.7368363

112263 7.04394

Main Warehouse

WA 1346.0554

112263 1.6735

112344 344.3819

112398 1000

2 PD 08-08-24

SAD 09-08-20

2.1720

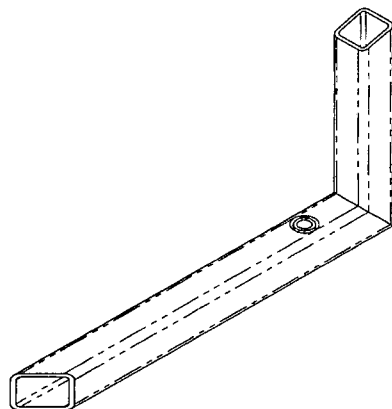
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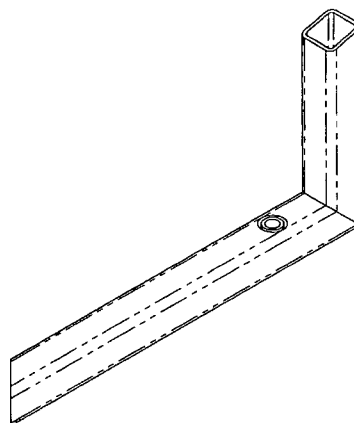
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NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51334
mf 09-08-14

RELEASED
08/11/12

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A
TITLE **RIB ASSY (BASKET LID)** SCALE NTS
SHEET 1 OF 3

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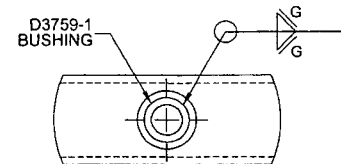
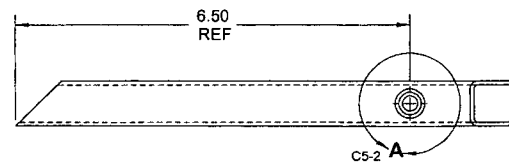
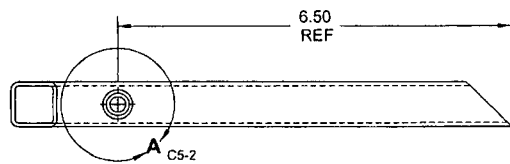
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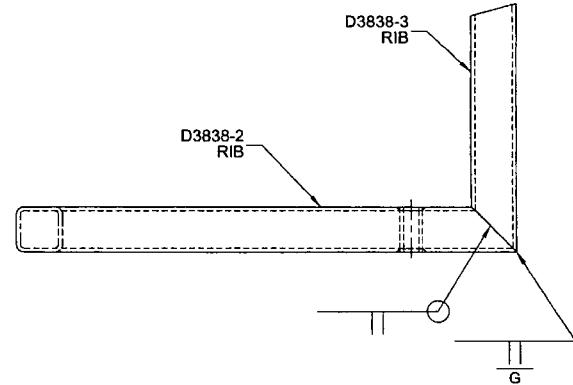
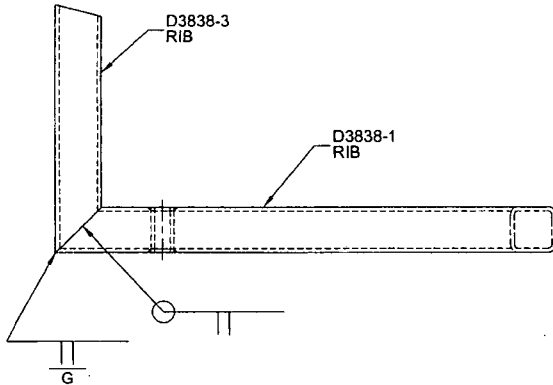
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DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, RH)

57334

RELEASED
08/11/81

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CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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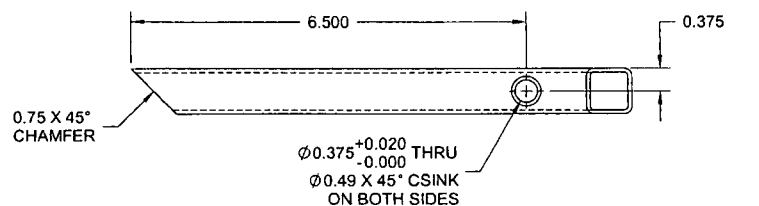
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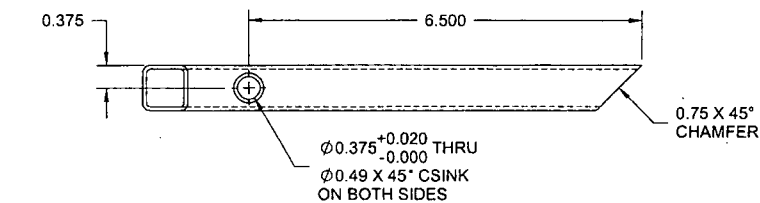
NOTE: Date & initial all entries

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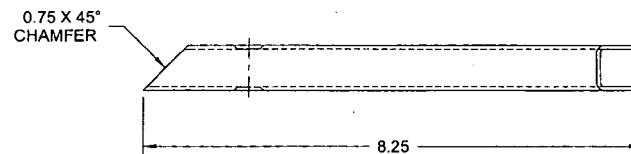
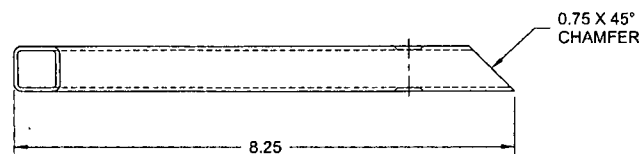


D3838-1 RIB

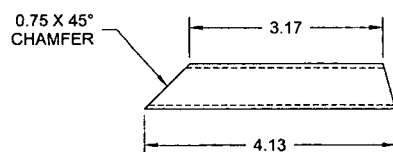


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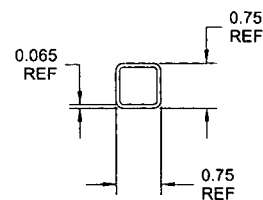
C



B



D3838-3 RIB



TYPICAL SECTION VIEW

51334

RELEASED

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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